Work Order ID 70293

Thursday, June 02, 2011 1:32:24 PM

Item ID:

D3207-5

**Revision ID:** Item Name:

Bracket

Start Date:

6/9/2011

QC:

Start Qty: 10.00



Accept



Setup Start



Page 1

Stop

Required Date: 6/17/2011

Req'd Qty: 10.00

**Cust Item ID: Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Date:

**Tooling:** 

SPC (Y/N):

Date:

Date:

Run

Start Stop



Sequence ID/ Work Center ID Operation Description

Set Up/ **Run Hours**  Tool ID

Tool # Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

**Draw Nbr** 

**Revision Nbr** 

D3207 Rev A

100

Waterjet

FLOW CNC Wateriet

6061.175

FLOW WATER JET

1-Cut as per Dwg D3207 Deburr if necessary

0.00

0.00

B11-6-8



110

QC2- Inspect parts off machine FAI/FAIB

0.00

Quality Control

Memo

0.00

B11-6-8

120

QC

QC8- Inspect parts - second check

Memo

Quality Control

W/O:		·	WC	RK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cate	gory:	NCR: `	Yes N	No DQA: Date:			
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Work Order ID 70293 Thursday, June 02, 2011 1:32:24 PM Item ID: D3207-5 Revision ID: Item Name: Bracket Start Qty: 10.00 **Start Date:** 6/9/2011 Required Date: 6/17/2011 Req'd Qty: 10.00 Reference: Approvals: Process Plan: QC: Sequence ID/

Accept

Setup Start

Stop

**Cust Item ID: Customer:** 

Date: Date:

Tooling: SPC (Y/N):

Date: Date: Run

Start Stop

Work Center ID

Operation Description Set Up/ **Run Hours**  Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

130

Brake NC Brake NC

NC BRAKE

Memo

Memo

Memo

Form as per Dwg D3207

0.00

0.00

Sp 11/06/13

140

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

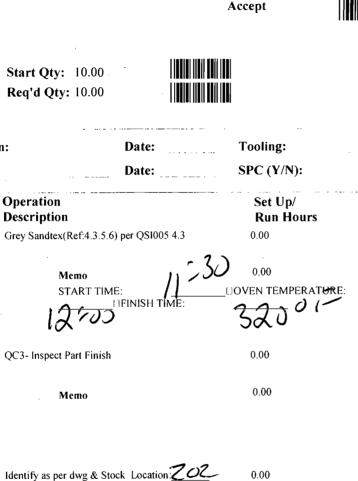
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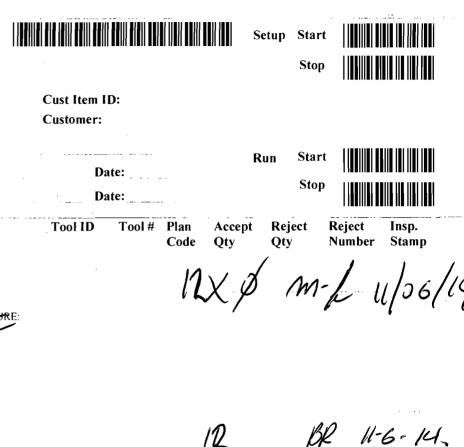
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#### Work Order ID 70293 Thursday, June 02, 2011 1:32:24 PM Item ID: D3207-5 Revision ID: Item Name: Bracket **Start Qty: 10.00 Start Date:** 6/9/2011 Req'd Qty: 10.00 Required Date: 6/17/2011 Reference: **Approvals: Process Plan:** QC:





180

Packaging

Quality Control

Sequence ID/

Powdercoat

160

170

Work Center ID

Packaging

QC3- Inspect Part Finish

Memo

**Operation** 

Description

Memo

0.00

W/O:			W	ORK ORDER CHANGI	ES				
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#### Work Order ID 70293

Thursday, June 02, 2011 1:32:24 PM

Item ID:

D3207-5

**Revision ID:** 

Bracket Item Name:

6/9/2011 **Start Date:** Required Date: 6/17/2011

**Start Qty: 10.00** 

Req'd Qty: 10.00



Accept



Setup Start

Stop



Reference:

Approvals: Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Cust Item ID:

**Customer:** 

Tool ID

Date:

Start

Stop

Sequence ID/ Work Center ID

190

Quality Control

Operation Description

OC21- Final Inspection - Work Order Release

Memo

0.00

0.00

Set Up/ **Run Hours** 

Tool#

Plan Accept Qty Code

Reject Qty

Run

Reject Number Stamp

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W/O:			W	ORK ORDER CHANG	ES				
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#### **Picklist Print**

Thursday, June 02, 2011 1:32:20 PM

Work Order ID: 70293

Parent Item:

D3207-5

Parent Item Name: Bracket



Start Date: 6/9/2011

Required Date: 6/17/2011

**Start Qty: 10.00** 

Required Qty: 10.00

Comments:

Component Item 1D/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 M6061T6S.125		Purchased	No	**		100	sf	108.5000	0.0736	0.774737	. 1	c	

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6061-T6 .125 Sheet

			B11-	6-8
<b>Location</b>	Loc Qty	Loc Code		
MAT021	108.5			7
113608	84.5			(1,
116700	24		116700	

Page 1

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DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng			ction C	Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	10093
		·
Description: Bracket	Part Number:	D3207-5
Inspection Dwg: D3207 Rev: A	!	Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X	First Articl	е	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.926	+/-0.010	7.976	4		V 1B/10Z	
2.376	+/-0.010	2.316	<b>*</b>		V	
3.200	+/-0.010	3.705	8		V	
R0.25	+/-0.030	<i>135</i>	Q		R.G.	
R0.50	+/-0.030	.50	9		R.G.	
R0.75	+/-0.030	.15	0		R.G.	,
Ø0.438	+0.005/-0.000	<u>[441</u>	>		٧	
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Measured by:	rB	Audited by:	Prototype Approval:	N/A
Date:	11-6-8	Date: Nac Off	Date:	N/A

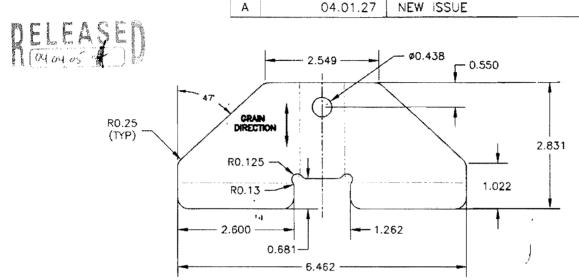
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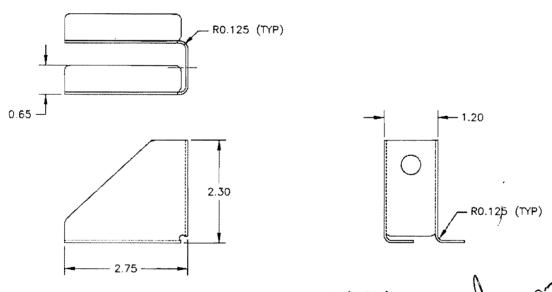




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	040407	NEW INC.		



#### D3207-1/-2 FLAT PATTERN



# D3207-1 BEND DETAIL (SHOWN) D3207-2 OPPOSITE

D3107-1/-2 BRACKET

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (M2024T3S.050)
  2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
  3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
  4 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE INCHES

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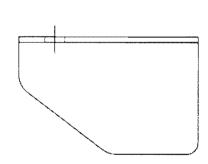
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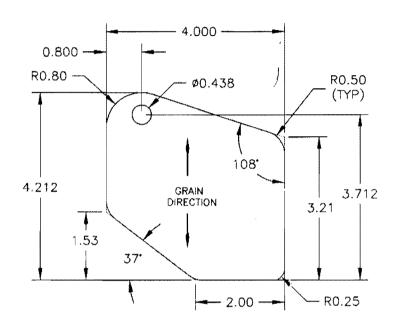


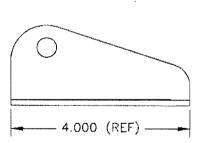


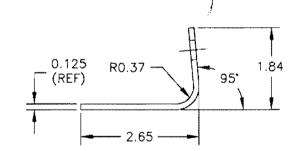
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D3207-3 FLAT PATTERN

#### D3207-3 BEND DETAIL

D3207-3 BRACKET

- 1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125) 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES

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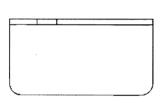
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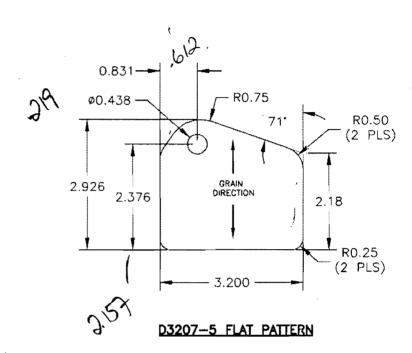


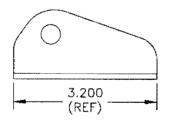


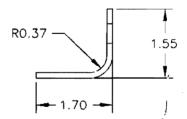
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# D3207-5 BEND DETAIL

D3207-5 BRACKET

1) BREAK ALL UNMARKED SHARP EDGES CORNER 0.005 TO 0.010

2) MATERIAL: 6061-T6 (QQ-A-250/11) 0.125" THICK (M6061T6S.125) 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE INCHES

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